

Date: Monday, 11/12/2007 10:51:37 AM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP EXTRUSION	
Job Number	: 35618		Part Number	: D2622120C	
Estimate Number	: 10058		Drawing Number	: D2622 REV C1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/12/2007	S.O. No.	: N/A	Drawing Revision	: C1
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 11/30/2007	
Previous Run	: 34694		Qty:	110 Um: Each	
Written By			<i>[Signature]</i>		
Checked & Approved By			<i>[Signature]</i>		
Comment	: Est. A: 02.11.12 New Issue KJ/RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		Comment: PURCHASING Issue P/O: <u>5013</u> <i>C\07/10/12</i>
		a) Extrude as per Dwg D2622 Rev. C b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required
2.0	D2622120CP	Extrusion
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 110.0000 Each(s)
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached
4.0	QC6	DIMENSIONAL CHECK
		Comment: DIMENSIONAL CHECK Inspect dimension per Dwg D2622 Check Pull test per Dwg D2622 for compliance page attached Check hardness with Webster tester

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/11/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP EXTRUSION

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOL/BF 07/11/29 (132)

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/30

(132)

Job Completion



W 07/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

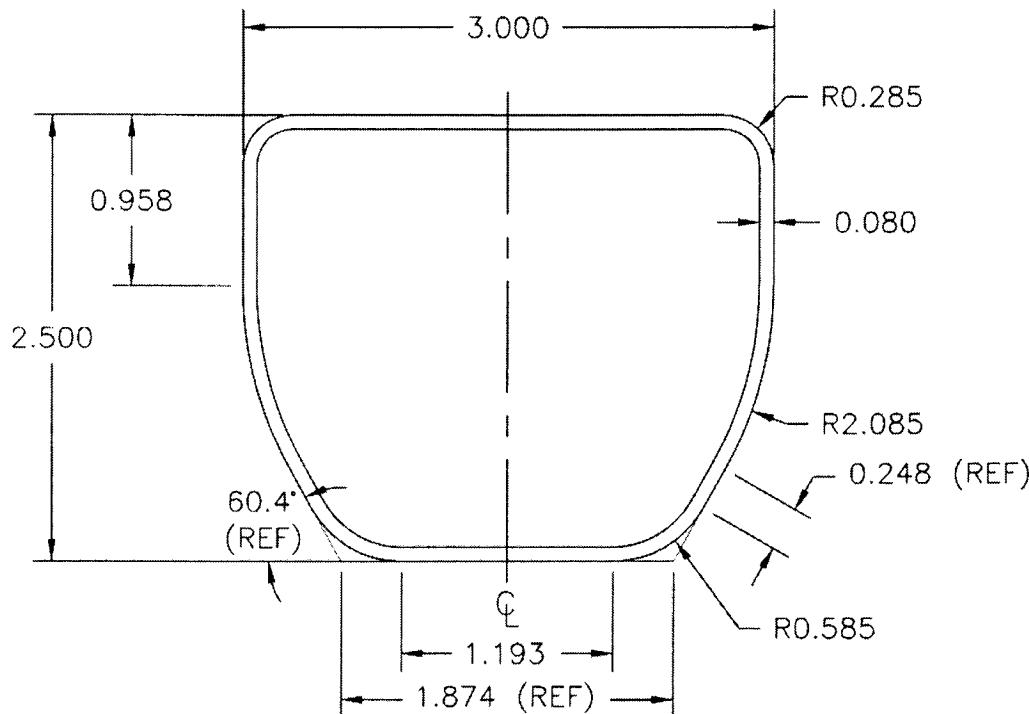
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE 02.09.11	TITLE STEP EXTRUSION		SCALE 1:1
A 96.11.29 NEW ISSUE			
B 97.12.12 CHANGE MATERIAL, ADD TOL. QSI			
C 02.09.11 0.080 WAS 0.085; ADD PART & DIE No.			
C1 <i>JP</i> 02-10-C4 AND 'REV-A' TO DIE NUMBER.			

RELEASED
[02.09.11] *H*



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
 MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W10: 3568

207/10/10



INVOICING COMPANY AND LOCATION
BUREAU DE FACTURATION

BON L CANADA INC
560 EDWARD AVENUE
RICHMOND HILL ON

SHIPPING MANIFEST
BORDEREAU D'EXPÉDITION

MANIFEST DATE/DATE D'EXPÉDITION
11-23-07

MANIFEST NUMBER/N° D'EXPÉDITION
421253

SALES ORDER NUMBER/N° DE COMM.
14251

LAD 479

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE.
RÉFÉREZ-VOUS À CES
NUMÉROS POUR TOUTE
CORRESPONDANCE.

MM 000000

401253

86 00 00 00 00

CREDIT REP/REP. DU CRÉDIT
PIMENTICK, PAUL
905-508-3250

SALES REP/REP. DES VENTES

FIELD SALES REP/REP. RÉGIONAL DES VENTES

CUST SERVICE REP/REP. SERVICE CLIENTÈLE

Kutter A
450-433-6551

Burton B
905-427-2327

SHIP TO/EXPÉDIÉ À PART AEROSPACE LTD. 270 ABERDEEN ST. WATKINSBURY ON N6A 1K7		SOLD TO/VENDU À PART AEROSPACE LTD. 1720 ABERDEEN ST. WATKINSBURY ON N6A 1K7		LOC/USINE KTM	TRAILER NO./N° DE REMORQUE 57275	SALESMAN/VENDEUR 59050	
PHONE 613-632-5200		PHONE 613-632-5200					

JSTOMER ID/N° DU CLIENT	ORDER DATE DATE DE LA COMMANDE	CUST. P.O. NO./N° DE COMM. DU CLIENT	JOB/PROJET	BILL OF LADING NUMBER/N° DE CONNAISSEMENT 00365098			
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ITEM NO. ITEM	ORDER QUANTITY QTÉ COMMANDEE	UNIT UNITÉ	PREVIOUS SHIPPED QTY. QTÉ DÉJÀ EXPÉDIEE	MFG. PART NUMBER N° DE PIÈCE DU FOURNISSEUR	ALLOY & TEMPER ALLIAGE & TREMPÉ	FINISH DESCRIPTION DESC. DE LA FINITION	THIS SHIPMENT/CETTE EXPÉDITION			UNIT UNITÉ	QUANTITY DUE QUANTITÉ PRÉVL		
				CUSTOMER PART NUMBER NUMÉRO DE PIÈCE DU CLIENT	LENGTH LONGUEUR	FABRICATION DESCRIPTION TYPE DE FABRICATION	NO. PKGS. N° DE PAQUETS	GROSS WT. POIDS BRUT	NET WT. POIDS NET				
					CUTTING TOLERANCE TOLERANCE DE COUPE	SHIPPING TOLERANCE TOLERANCE D'EXPÉDITION							
01	121	KG M PC	0	01004-B07133-1 0 02622	6061 /16 1200 +0.006 -0.000	ATL CERTIFICATE OF COMP (015-015.0139-0102)	2	571	547	KG	0		
				DETAILS : LOT/TICKET		14251010 / 181102 14251010 / 181103	4	298	293	M	0		
							4	272	261	PC	0		
											132		
											69 PC		
											69 PC		

CRM NO. B1065 REV. D
O RETURN MATERIALS WILL BE ACCEPTED FOR CREDIT WITHOUT PERMISSION
UCUN RETOUR DE MATERIEL NE SERA ACCEPTÉ POUR CRÉDIT SANS AUTORISATION

CUSTOMER
CLIENT

PAGE:

TOTAL/TOTAUX



CERTIFICATE OF COMPLIANCE

BON L CANADA INC

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Expedited	Cert. No.	Sales Order	Page
11/23/07	169640	14251	1
5013	00365098	14251010	11/23/07

DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7
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Item No.	Part No.	Item Description			Cust. Part
1.000	DAA-897123-1	120" Mill 6061 T6			D2622
Gross Weight:	571 KGS				
Net Wt.	547 KG	132 PC	402 M	2 PKG	
Specification:	AMS-QQ-A-200/8 & ASTM B221-00				

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift	HREW
1	307.6 / 44.6	277.3 / 40.2	10.5	.0	.96	

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.66	.24	.28	.07	.92	.07	.006	.06	.000	.009	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada